

Work Order ID 129676

February-23-15 10:15:33 AM

646.9711

B129676

129676

Page 1

Item ID: 646.9711

Revision ID:

Item Name: Blade

Start Date: 2/23/15 Start Qty: 50.00

Required Date: 2/23/15 Req'd Qty: 50.00

Reference:

REV. C

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MS Date: 1502-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.9700	C (ECN)								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 4.625"

50

0

15/02/27

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB135

DWG REV: C

FOLIO REV: AA

50

36

15-03-01

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 129676

February-23-15 10:15:33 AM

129676

Page 2

Item ID: 646.9711

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 2/23/15

Start Qty: 50.00

50

Cust Item ID:

Required Date: 2/23/15

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

50

BG

15-03-01

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

50

X

DAS
44
9-89
15/03/05

140

Outsource process - Heat Treat

0.00

140

Outsource1

Memo

0.00

Outsource process - Heat Treat

HEAT TREAT AS PER DWG, SEE NOTE #3

ISSUE P/O: 27683

CY 1510 3106 (50)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129676

February-23-15 10:15:33 AM

129676

Page 3

Item ID: 646.9711

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 2/23/15 Start Qty: 50.00

50

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>131277</u>								

50x SP15-eu-29

(50)

DAS
38
9-89

APR 29 2015

DAS
41
9-89

50

15-5-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:15:33 AM

Page 1

Work Order ID: 129676

129676

Parent Item: 646.9711

646 9711

Parent Item Name: Blade

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	61.7000	0.386	20.31579			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

**

WSP
15/02/27

Location

MAT010

Loc Qty

61.7

Loc Code

(M126438)

61.7

20,508

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04559

SHEET 1 OF 1

DWG. NO. 646.9700

REV: C

PREPARED BY

D. MEJIA

DATE: 06/11/2014

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

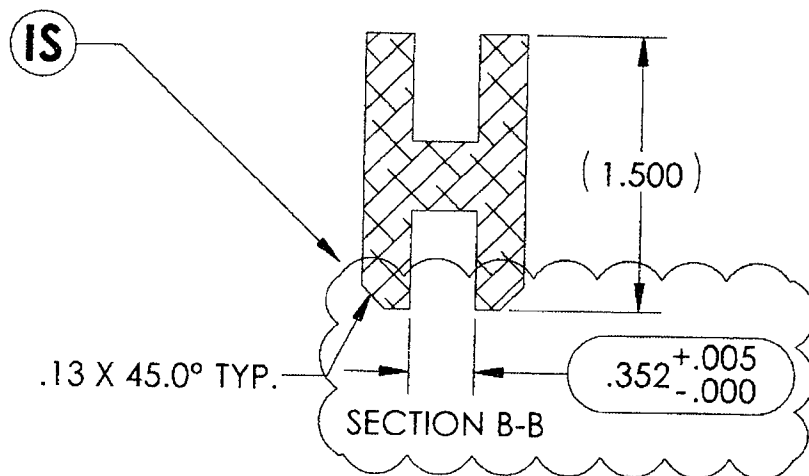
TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: ADDED DIMENSION AND TOLERANCE

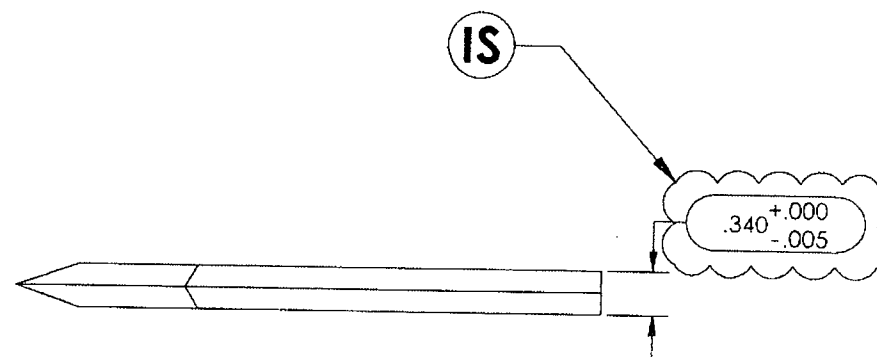
ECR:

D-14-05

SHEET 2, ZONE D7 IS:



SHEET 5, ZONE B5 IS:



SDA
F

129676 NLS
150224

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

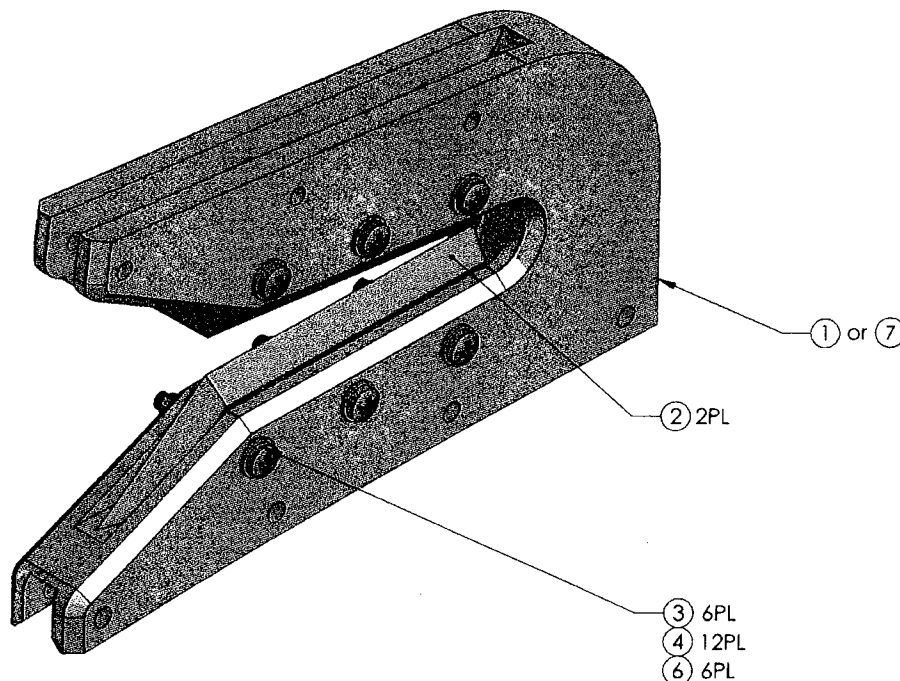
☐ YES ☒ NO

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
INITIAL RELEASE	LAST PROTOTYPE REVISION: PR2		RAC
A	INCORPORATED ECN 02741, 02636, 02912	02/27/09	P. BRAVO
B	INCORPORATED ECN 03167	07/03/13	P. BRAVO
C	INCORPORATED ECN 04037	08/06/13	P. BRAVO

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



646.9701
or
646.9702

UNINCORPORATED ECN(s)

0455A

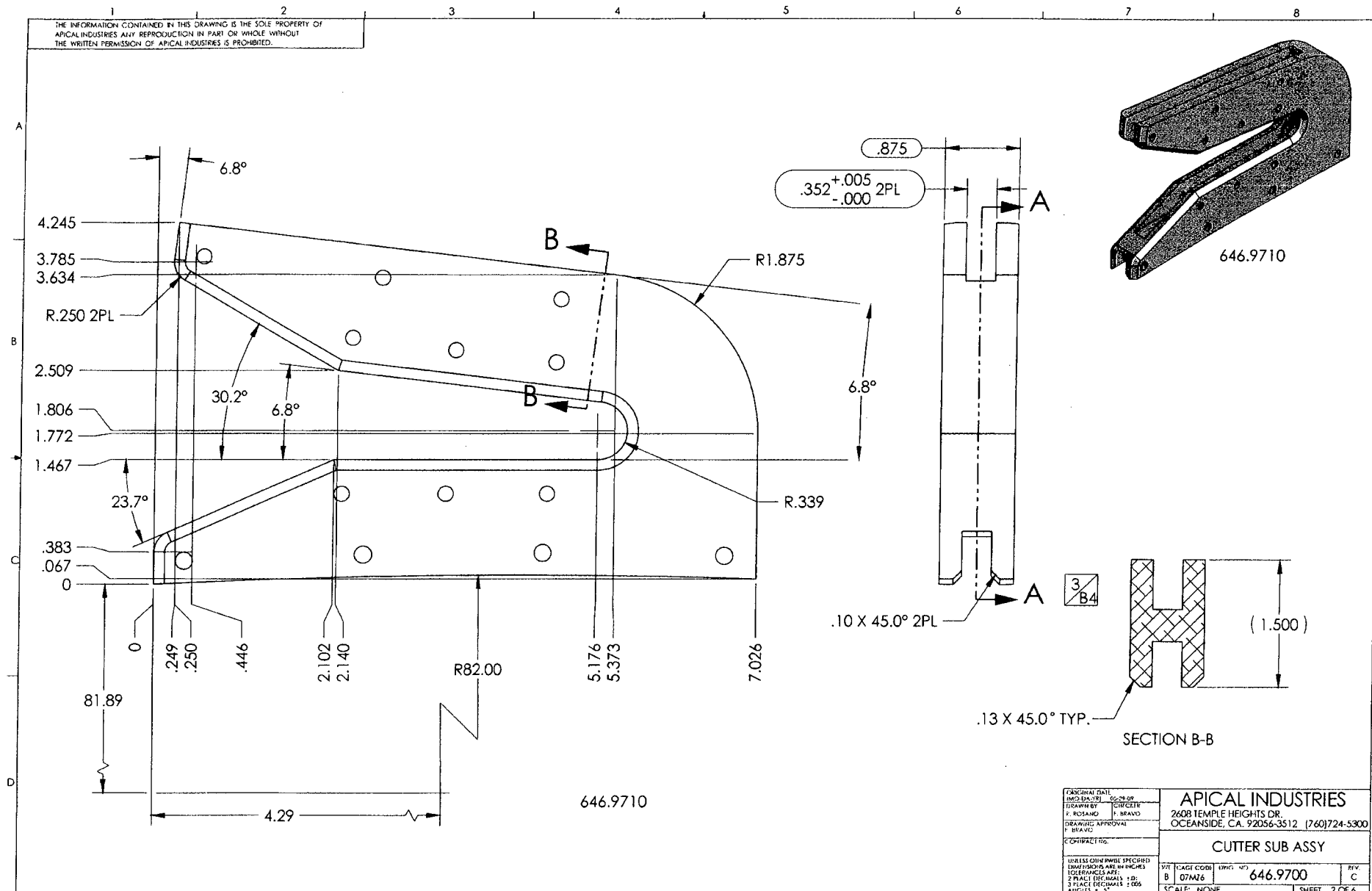
1	6	6	6	646.9712	BODY (U CHANNEL)	△	△
6	6	6	6	601.1541	LOCKNUT	M521042108	
A/R	A/R	A/R	5	601.2764	RTV, LOCTITE 598		
12	12	4	4	601.2764	WASHER	M52114910832P	
6	6	3	3	601.2765	SCREW	M527039-0819	
2	2	2	2	646.9711	BLADE	△	△
1	1	1	1	646.9710	BODY	△	△
				646.9702	CUTTER SUB ASSY (U CHANNEL)		
				646.9701	CUTTER SUB ASSY		
QTY	QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
PARTS LIST							
NEXT ASSY [S]				ORIGINAL DATE: 05-29-08			
646.9600				DRAWN BY: R. ROSARIO			
				CHECKED BY: P. BRAVO			
				DRAWING APPROVAL: P. BRAVO			
				DATE: 05-29-08			
				CUTTING EDGE: 0.005			
				UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				2 PLACE DECIMALS ± .01			
				3 PLACE DECIMALS ± .005			
				ANGLES ± .5°			
				SCALE: NONE			
				SHEET: 1 OF 6			

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSY

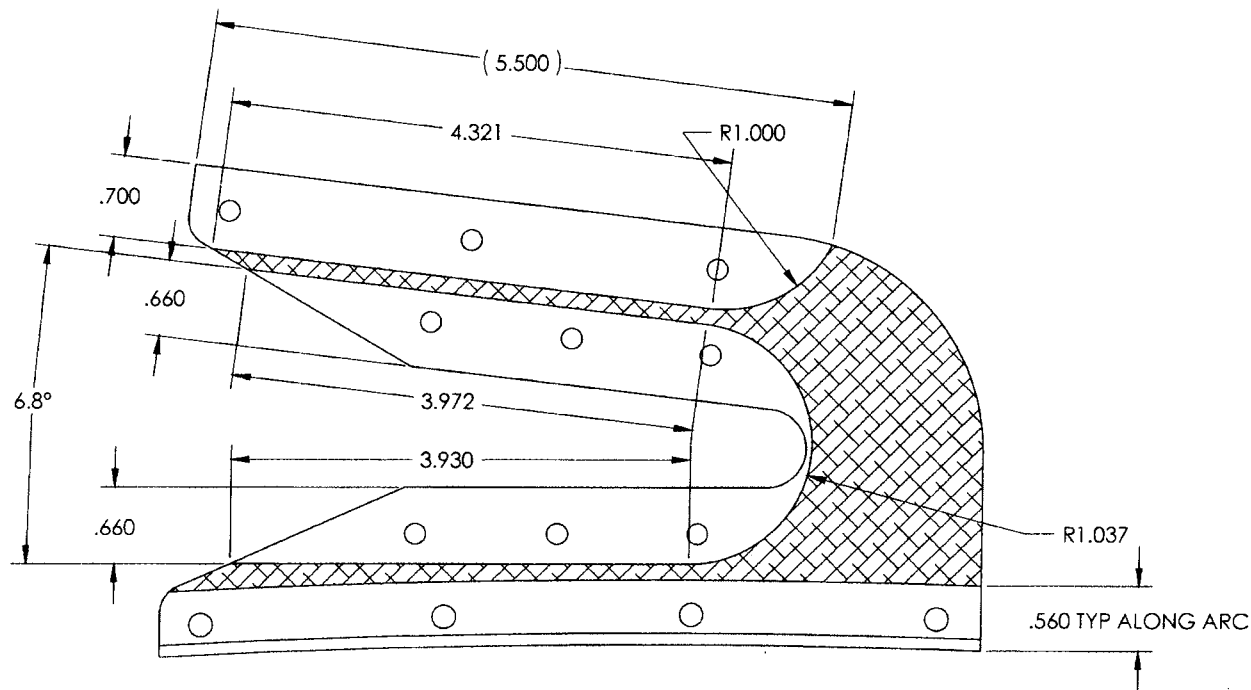
DATE: 07/02/09 ENG: 646.9700 PTC: C

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



ORIGINAL DATE: 06-28-00		APICAL INDUSTRIES	
DESIGNED BY: F. ROSANO		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: F. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
C/CHECKED BY:		CUTTER SUB ASSY	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		3/4" (PAGE CODE)	REV. C
TOLERANCES ARE:		B 07M16	646.9700
2 PLACE DECIMALS 1/16"		SCALE: NONE	SHEET 2 OF 6
3 PLACE DECIMALS 1/32"			
ANGLES ± 5°			

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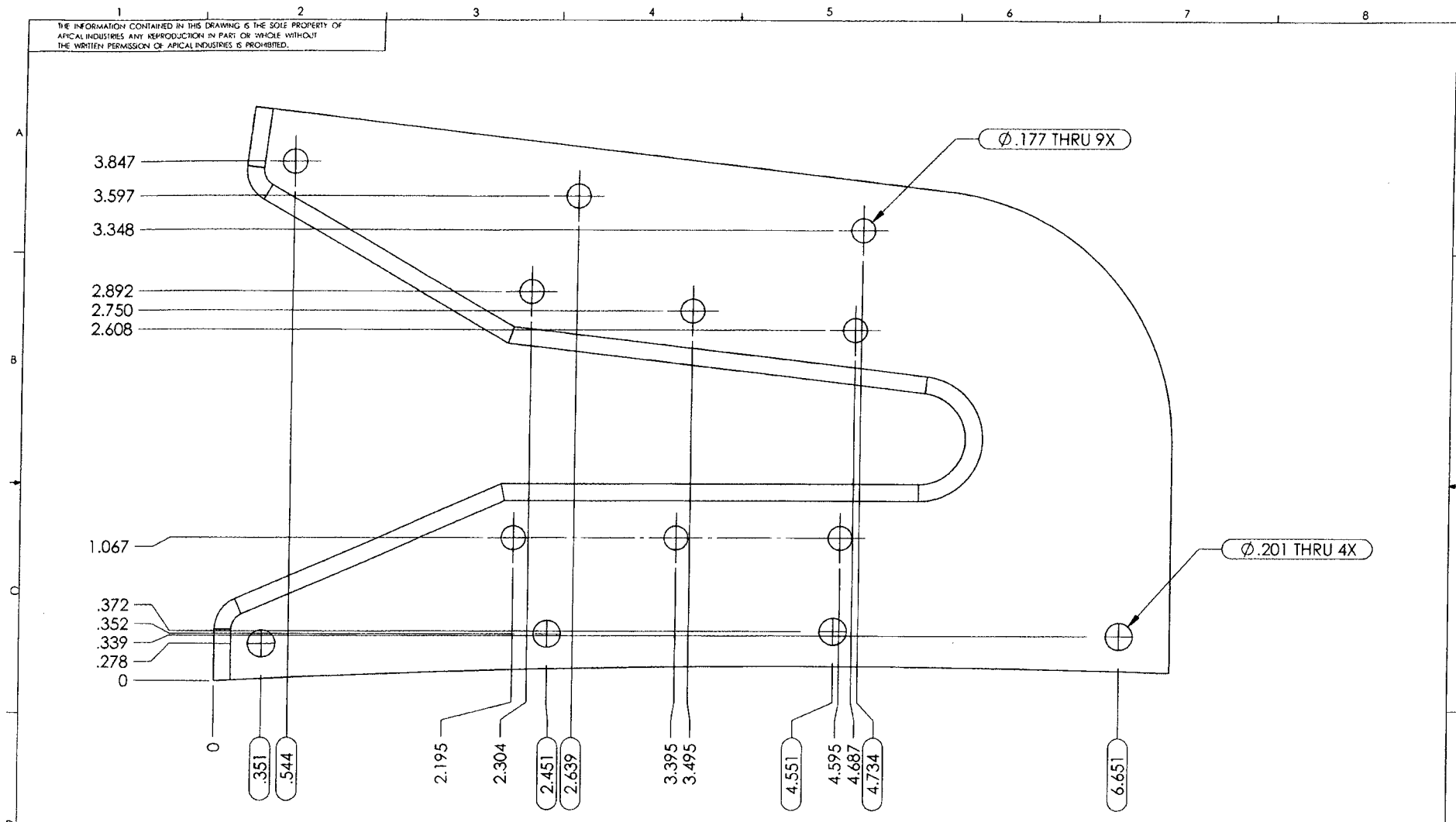


SECTION A-A $\frac{2}{C6}$

646.9710

ORIGINAL DATE: 02/20/00 DESIGNER: J. HICKS DRAWN BY: H. ROSA MD CHECKED BY: P. BRAYO DRAWING APPROVAL: P. BRAYO DATE: 06/20/00 CONTRACT NO.				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°				CUTTER SUB ASSY			
REV	DATE	BY	CHKD	REV	DATE	BY	CHKD
8	07/02/00						
SCALE: NONE				SHEET 3 OF 6			

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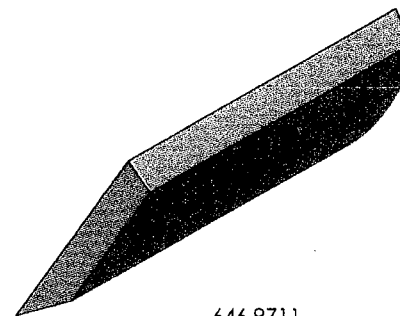
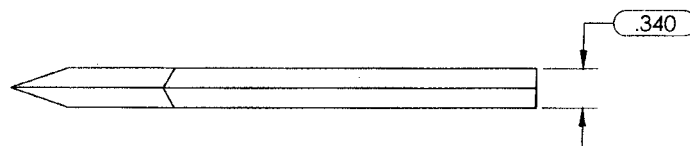


HOLE LOCATIONS +/- .002

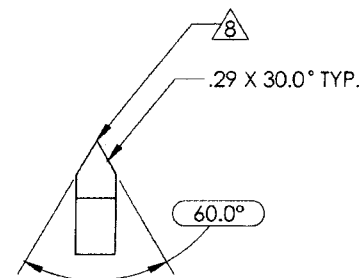
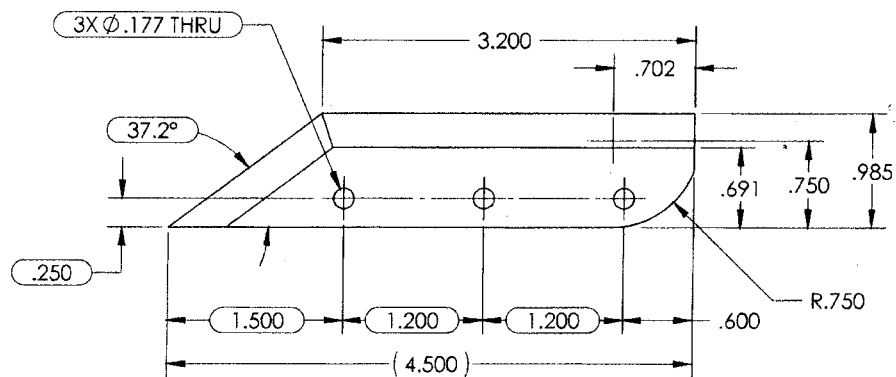
646.9710

ORIGINAL DATE: 10-26-88		APICAL INDUSTRIES	
DRAWN BY: J. KOSMANE		2608 TEMPLE HEIGHTS DR.	
ENGINEERING APPROVAL: J. KOSMANE		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		CUTTER SUB ASSY	
UNLESS OTHERWISE SPECIFIED		TEL: 07N26	REV: C
DIMENSIONS ARE IN INCHES		646.9700	
TOLERANCES ARE:		SCALE: NONE	
FRACTIONS DECIMALS ±.01		SHEET 4 OF 6	
HOLE LOCATIONS ±.002			
ANGLES ±.5°			

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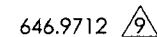
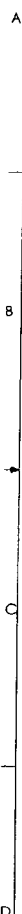


646.9711



646.9711

ORIGINAL DATE: 05-29-89		APICAL INDUSTRIES	
DRAWN BY: R. ROSARIO		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: P. BRADY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		CUTTER SUB ASSY	
DATE: 07-11-89	CASE CODE: B	DWG. NO: 646.9700	REV: C
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.		SCALE: NONE	
TOLERANCES ARE:		SHEET 5 OF 6	
2 PLACE DECIMALS ± .005			
3 PLACE DECIMALS ± .001			
ANGLES ± .5°			



646.9712

LOCATION DATE (MAY 24 1981) 05-29 09		APICAL INDUSTRIES	
DRAWN BY C. RUSSO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAVO			
DRAWING APPROVAL P. BRAVO 05-29-81			
CONTRACT NO.		CUTTER SUB ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN DECIMALS TOLERANCES ARE: 1/32 3 PLACES DECIMALS ± .010 4 PLACES DECIMALS ± .005		MFG. CODE DPM46	QTY. NO. 646.9700
		SCALE NONE	SHEET 6 OF 6



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27683**

Purchase Order Date 3/6/2015

PO Print Date 3/6/2015

Page Number 1 of 2

Order From :

VC-MET004

Ship To : DART AEROSPACE LTD

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

450 473 1884

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Overnight collect

FOB

FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
----------	---	------------------------	--------------------------------------	----	--------------------------------	---------------	-------------------

1	129676	646.9711 BLADES	3/17/2015 Yes 3/17/2015		50.00	\$6.50	\$325.00
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FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

PLEASE NOTE: DETAIL C OF C REQUIRED

SP15-01-29

Line Total: \$325.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	3/17/2015 No 3/17/2015		1.00	\$0.00	\$0.00
---	----------	--------------------------------	------------------------------	--	------	--------	--------

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A020 non-destructive test/inspection identification
A021 dart aerospace processing
A024 process certifications
A026 certification of material conformance

Note:

3/6/2015

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
301287	1	101328

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
27683		A2	4/8/2015	

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-----------------------	------------------------------	---	-----------------

50 646,9711

REF: 203496

14,

SP15-04-29

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing	
-------------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 50

POIDS EXPÉDIÉ / Weight Shipped : 14,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 50

POIDS EXPÉDIÉ / Weight Shipped : 14,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 04/09/2015

METCOR INC.

560 BOUL. ARTHUR SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection**Inspection Report**

BON DE TRAVAIL order	CHARGEMENT load
301287	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
27883		A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement		SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed
HARDNESS		58 - 62 HRC		5
				RÉSULTATS DE TESTS / results
				50 - 60 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
50	14	646,9711 REF: 203496		

SP15-04-29

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2015-04-27

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
301287	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
27683		A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
<u>EXIGENCE / requirement</u> <u>SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed</u> <u>RÉSULTATS DE TESTS / results</u>				
HARDNESS 58 - 62 HRC 5 59 - 60 HRC				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
50	14	646,9711 REF: 203496		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1:30 HR
DOUBLE TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

APPROUVÉ par / Approved by:

Isabel Otero
QA Technician



DATE: 2015-04-28